

Work Order ID 91744

91744

Page 1

October-17-12 10:38:35 AM

Item ID: 647.1611E Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Wiper Deflector
 Start Date: 10/17/12 Start Qty: 120.00 *120* Cust Item ID:
 Required Date: 11/16/12 Req'd Qty: 120.00 *120* Customer:
 Reference:

Approvals: Process Plan: W Date: Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
647.1600	N/C								
100	PURCHASING	0.00							
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 18148								
	a) Description: EXTRUSION FOR DEFLECTOR								
	c) Material: 7075-T6								
	f) Material certification required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.00							
Packaging	Ensure material certification is attached								
120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control	Ensure Material certification comply to Dwg 646.9800								

CX 12/10/17 (120)

12/14/12 (132)

12/11/12

132

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY									
Landing Gear			General						
<input type="checkbox"/> Bending	<input type="checkbox"/> Bend	<input type="checkbox"/> Grain	<input type="checkbox"/> Ovalized	<input type="checkbox"/> Pressure/Forced					
<input type="checkbox"/> Centre Not Concentric to O/S	<input type="checkbox"/> BOM/Route	<input type="checkbox"/> Hardware	<input type="checkbox"/> Over/Under tolerance	<input type="checkbox"/> Temperature/Cure					
<input type="checkbox"/> Cracks	<input type="checkbox"/> Broken/Damaged	<input type="checkbox"/> Inspection Incomplete	<input type="checkbox"/> Part Incorrect	<input type="checkbox"/> Weld					
<input type="checkbox"/> Crushed/Crimped	<input type="checkbox"/> Burrs	<input type="checkbox"/> Instructions Incomplete/Unclear	<input type="checkbox"/> Part Lost/Missing	<input type="checkbox"/> Wrong Stock Pulled					
<input type="checkbox"/> Cuffs	<input type="checkbox"/> Contamination	<input type="checkbox"/> Maintenance	<input type="checkbox"/> Part Moved						
<input type="checkbox"/> Heat Treat	<input type="checkbox"/> Countersink	<input type="checkbox"/> Mislabeled	<input type="checkbox"/> Positioned Wrong						
<input type="checkbox"/> Inspection Strip in Tube	<input type="checkbox"/> Cut Too Short	<input type="checkbox"/> Misread	<input type="checkbox"/> Power Loss/Surge	<input type="checkbox"/> Other					
<input type="checkbox"/> Ripples in Bend	<input type="checkbox"/> Drill Holes	<input type="checkbox"/> Offset							
<input type="checkbox"/> Torque Waves in Extrusion	<input type="checkbox"/> Drawing	<input type="checkbox"/> Out of Calibration							
<input type="checkbox"/> Turning Sequence	<input type="checkbox"/> Finish	<input type="checkbox"/> Out of Sequence							
<input type="checkbox"/> Wave/Twist in Tube	<input type="checkbox"/> Folio	<input type="checkbox"/> Outside Dimensions							

Work Order ID 91744

91744

Page 2

October-17-12 10:38:35 AM

Item ID: 647.1611E Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wiper Deflector
 Start Date: 10/17/12 Start Qty: 120.00 ***120*** Cust Item ID:
 Required Date: 11/16/12 Req'd Qty: 120.00 ***120*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <i>MT 34</i>	0.00							
130									
Packaging	Memo	0.00		<i>12/11/27</i>		<i>132</i>			
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							<i>12/11/28</i>
Quality Control									

012-11-27

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
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Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other

Picklist Print

October-17-12 10:38:35 AM

Page 1

Work Order ID: 91744

Parent Item: 647.1611E

Parent Item Name: Wiper Deflector

Start Date: 10/17/12

Required Date: 11/16/12

Start Qty: 120.00

Required Qty: 120.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
647.1611P Wiper Deflector		Purchased	No				f	0.0000		120			

10/24/12 (132)

NCR: Yes / No

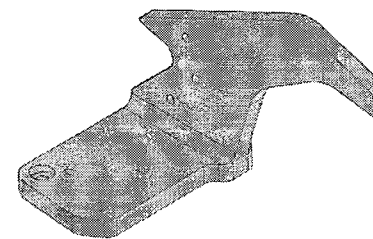
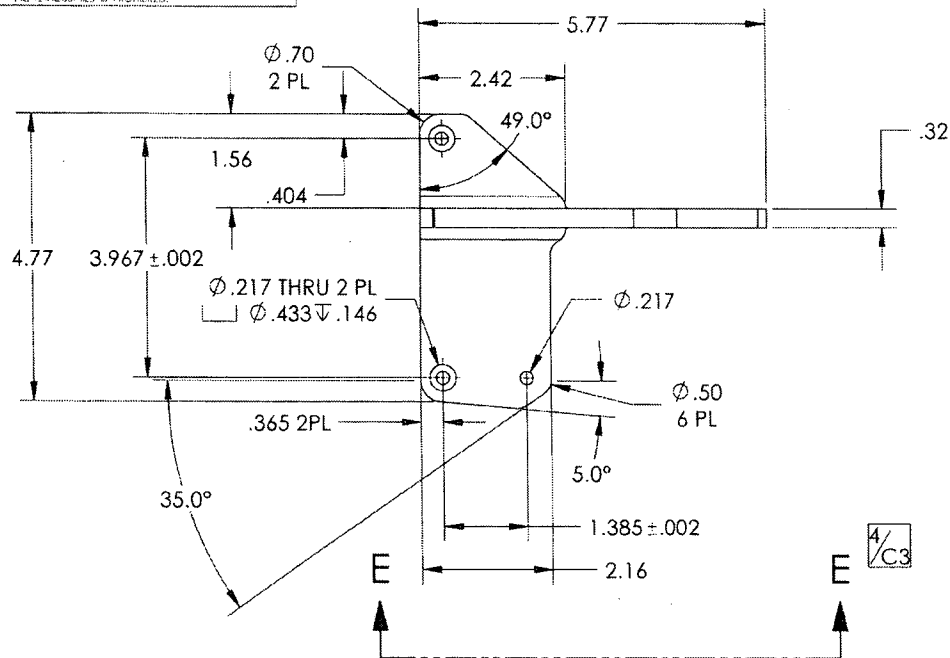
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

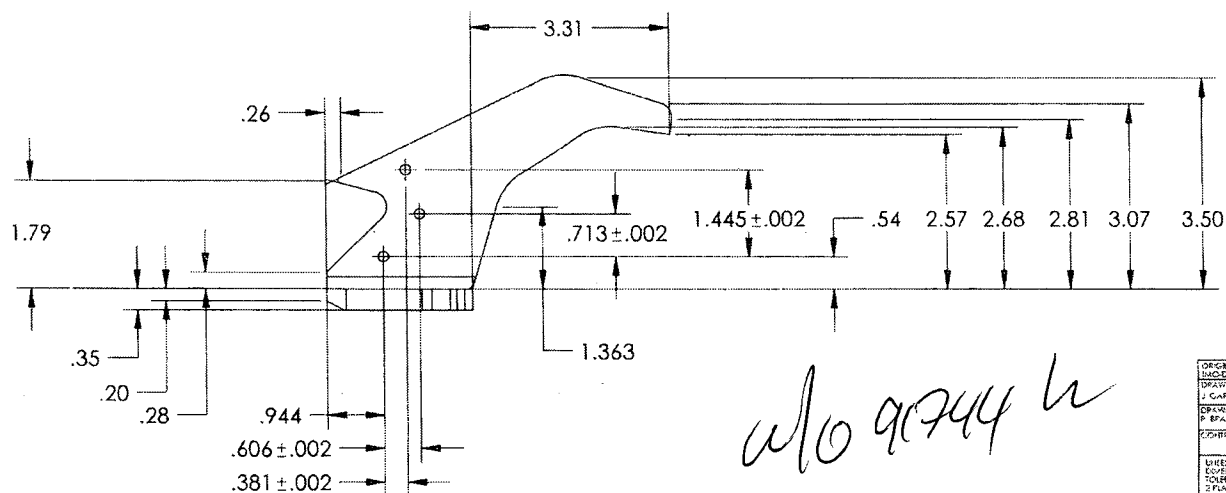
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647.1611



W/O 90744 h

ORIGINAL DATE		APICAL INDUSTRIES	
REVISIONS		2608 TEMPLE HEIGHTS DR.	
DESIGNED BY		OCEANSIDE, CA. 92056-3512. (760) 724-5300	
CHECKED BY		WIPER DEFLECTOR ASSY	
DRAWING APPROVAL		REV.	
P. BRAVO		N/C	
2/28/87		SCALE: NONE	
SHEET 3 OF 6		SHEET 3 OF 6	

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

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Unapproved											

FAULT CATEGORY				
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube	General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio	<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions	<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO18148

Purchase Order Date 10/17/12

PO Print Date 10/18/12

Page Number 1 of 1

Order From :

VU-UAC001

UNIVERSAL ALLOY CORPORATION
2871 LA MESA
P.O. BOX 6316

ANAHEIM, CALIFORNIA 92816-8316
USA

Contact Name

Vendor Phone

Vendor Fax 714-630-7207

Vendor Account Nbr

Buyer

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Ship To : DART AEROSPACE LTD 1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAXED
10/18/12

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
3	647.1611P	Wiper Deflector	12/03/12 Yes	120.00 f	Journey Freight	\$44.6780	\$5,361.36

Special Inst: AS PER DWG D647.1611
B91744
MATERIAL: 7075-T6 AS PER AMS- QQ-A-
200/11

QUOTATION #326429

PO Total:

\$5,361.36

MATERIAL CERTIFICATION
REQ'D UPON DELIVERY

Change Nbr: 5

Change Date: 10/18/12

No substitution or deviation without
consent.

Certificate of Conformity or Material
Certification required YES NO

SHIPPER NO.

406022-1

UACPART NO.

66743

UNIVERSAL ALLOY CORPORATION
 2871 JOHN BALL WAY, P.O. BOX 6316, ANAHEIM, CA USA 92816-6316
 (714) 630-7200 (800) 331-7772 FAX (714) 630-7207

PRODUCTION LOTS

A555270

S
H
I
P
T
O

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY, ONTARIO CN, K6A 1K7

S
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D
T
O

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY, ONTARIO CN, K6A 1K7

27/320

CUSTOMER'S P.O. NO.

PO18148 item 1

ORDER PLACED BY

CHANTAL LAVOIE

CUSTOMER'S PART NUMBER

647.1611-EXT ALUMINUM EXTRUSION

TERMS

NET 60

ALLOY

7075 T6

SPECIFICATION NO.

AMS-QQ-A-200/11 REV. N/C

SHIP VIA

JOURNEY FREIGHT

DATE SHIPPED

11/15/2012

FREIGHT CHARGES

PREPAID ☒ COLLECT ☐

SHIPMENT

PARTIAL ☐ COMPLETE ☒

CERTIFICATIONS

ATTACHED ☒ TO FOLLOW ☐**QUANTITY SHIPPED**

FEET	PIECES X LENGTH	NET PER PC	NET POUNDS	GROSS POUNDS	BOX
132	11 X 144.	43.45	478	556	1 bundle of 3 fiber board with plywood caps
RECEIVED BY X			DATE	TIME	boxes

UNIVERSAL ALLOY CORPORATION ACCEPTS NO RESPONSIBILITY FOR ERROR IN SHIPMENT IF YOU FAIL TO NOTIFY US WITHIN 3 DAYS OF RECEIPT. NO REJECTED MATERIAL WILL BE ACCEPTED FOR CREDIT OR REPLACEMENT AFTER 30 DAYS FROM DATE OF RECEIPT.

THIS SUPPLIER HAS BEEN DELEGATED BOEING INSPECTION AUTHORITY FOR ALL PARTS MANUFACTURED UNDER CONTRACT WITH THE BOEING COMPANY

SHIPPER NO.

406022-1

UACPART NO.

66743

UNIVERSAL ALLOY CORPORATION
 2871 JOHN BALL WAY, P.O. BOX 6316, ANAHEIM, CA USA 92816-6316
 (714) 630-7200 (800) 331-7772 FAX (714) 630-7207

PRODUCTION LOTS

A555270

S
H
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T
O

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY, ONTARIO CN, K6A 1K7

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JOURNEY FREIGHT

DATE SHIPPED

11/15/2012

FREIGHT CHARGES

PREPAID ☒ COLLECT ☐

SHIPMENT

PARTIAL ☐ COMPLETE ☒

CERTIFICATIONS

ATTACHED ☒ TO FOLLOW ☐**QUANTITY SHIPPED**

FEET	PIECES X LENGTH	NET PER PC	NET POUNDS	GROSS POUNDS	BOX
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UNIVERSAL ALLOY CORPORATION

2871 JOHN BALL WAY ANAHEIM, CA 92806 (714) 630-7200

EXTRUSION MILL CERTIFICATE OF CONFORMANCE INSPECTION AND TEST REPORT

CUSTOMER DART AEROSPACE LTD

PURCHASE ORDER PO18148 item 1 DATE 11/12/12

ORDER NUMBER 406022 PART NO. 647.1611-EXT rev N/C

SPECIFICATIONS AMS-QQ-A-200/11 REV. N/C MATERIAL 7075-T6

MECHANICAL PROPERTIES

SAMPLE OR LOT	TEST DIRECTION	TEST LOCATION	TENSILE STRENGTH KSI	YIELD STRENGTH KSI	ELONGATION %
A555270	L		89.1	81.1	12.3

*12/11/12
t.e. 11/12/12*

MANUFACTURED IN THE U.S.A.

CHEMICAL COMPOSITION LIMITS										
ALLOY NOS	SI	FE	CU	MN	MG	CR	ZN	TI	EACH	OTHERS TOTAL
7075	0.40	0.50	1.2-2.0	0.30	2.1-2.9	0.18-0.28	5.1-6.1	0.20	0.05	0.15

THIS IS TO CERTIFY THAT THE MATERIAL APPLIED TO THE ABOVE ORDER COVERED BY THIS REPORT HAS BEEN INSPECTED IN ACCORDANCE WITH THE SPECIFICATIONS DESCRIBED FORMING A PART OF THIS ORDER AND THAT REPRESENTATIVE MATERIAL HAS BEEN TESTED AND FOUND TO MEET THE APPLICABLE REQUIREMENTS. FURTHER SHOWN ARE THE COMPOSITION LIMITS AND MECHANICAL PROPERTY TEST RESULTS. DOCUMENTATION VERIFYING CONFORMANCE TO THESE REQUIREMENTS IS ON FILE AND SUBJECT TO EXAMINATION.

PERCENT MAXIMUM UNLESS SHOWN OTHERWISE
REMAINDER ALUMINUM

UNIVERSAL ALLOY CORPORATION

Ricardo Gallegos

Ricardo Gallegos - Quality Engineer Manager
QUALITY ASSURANCE DEPARTMENT





Universal Alloy Corporation

Invoice Number
630799

2871 John Ball Way
Anaheim, California 92806-0316
714.630.7200 - 800.331.7772 - Fax 714.630.7207

Please Remit To:
P.O.Box 951501
Dallas, TX 75395-1501

Please Send All Correspondence to: 180 Lamar Haley Pkwy. Canton, GA 30114

Sold To:
DART AEROSPACE
1270 ABERDEEN

Shipped To:
DART AEROSPACE
1270 ABERDEEN

HAWKESBURY, ONTARIO, CN K6A 1K7

HAWKESBURY, ONTARIO, CN K6A 1K7

27/320

Date 11/15/2012	Shipped Via JOURNEY FREIGHT	Shipper No. 406022-1	Date Shipped 11/15/2012	Terms NET 60	
Purchase Order Number PO18148 ITEM 1		Part Number 647.1611-EXT Rev N/C			Die Number
QUANTITY	DESCRIPTION			UNIT PRICE	AMOUNT
132.000	ALUMINUM EXTRUSION			44.680/FT	\$5,897.76
NO REJECTED MATERIAL WILL BE ACCEPTED FOR CREDIT OR REPLACEMENT AFTER 30 DAYS FROM DATE OF RECEIPT. UNIVERSAL ALLOY CORP. ACCEPTS VISA, MASTERCARD, AND AMERICAN EXPRESS					\$5,897.76

TOTAL
U.S. Dollars

CUSTOMER COPY



**North American Free Trade Agreement
CERTIFICATE OF ORIGIN**
(Instructions Attached)

Please Print or Type

1 Exporter's Name and Address: Universal Alloy Corporation 2872 E. La Palma Ave. Anaheim, CA 92806 <div style="border: 1px solid black; padding: 2px; float: right;"> Tax Identification Number: 95-2146793 </div>	2 Blanket Period: <div style="text-align: center;"> DD MM YY DD MM YY From 01 01 12 To 31 12 12 </div>
3 Producer's Name and Address: Universal Alloy Corporation 2872 E. La Palma Ave. Anaheim, CA 92806 <div style="border: 1px solid black; padding: 2px; float: right;"> Tax Identification Number: 95-2146793 </div>	4 Importer's Name and Address: DART AEROSPACE 1270 ABERDEEN HAWKESBURY, ONTARIO CN, K6A157 <div style="border: 1px solid black; padding: 2px; float: right;"> Tax Identification Number: </div>

5 Description of Good(s)	6 HS Tariff Classification Number	7 Preference Criterion	8 Producer	9 Net Cost	10 Country of Origin
ALUMINUM EXTRUSIONS	7604.29	B	Yes	\$5897.76	USA

11 I certify that: - the information on this document is true and accurate and I assume the responsibility for proving such representations. I understand that I am liable for any false statements or material omissions made on or in connection with this document; - I agree to maintain, and present upon request, documentation necessary to support this Certificate, and to inform, in writing, all persons to whom the Certificate was given of any changes that would affect the accuracy or validity of this Certificate; - the goods originated in the territory of one or more of the Parties, and comply with the origin requirements specified for those goods in the North American Free Trade Agreement, and unless specifically exempted in Article 411 or Annex 401, there has been no further production or any other operation outside the territories of the Parties; and - this Certificate consists _____ pages, including all attachments.
--

Authorized Signature:	Company: Universal Alloy Corporation
Name: Liliana Marquez	Title: Shipping tech
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